

Date: Monday, 17/07/2006 9:19:35 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D212-722-111
Job Number : 27930	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z_CUSTO 1
This Issue : 17/07/2006 S.O. No. : N/A	Drawing Number : ADD PAPERWORK
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : N/A	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : _____	Due Date : 24/07/2006 Qty: 4 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
ADD PAPERWORK EASA STC: EASA.IM.R.S.01181
TO KITS IN STOCK
D212-722-011 B 23334
CLOSE BOXES

PB 06/10/25 (4)

2.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
INSPECT LEVEL 21

DP 06/10/26 (4)

Job Completion



U 06-10-26

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD		Amendment Design Review (ADR) Yes/No: NO		ECN #: 833
Date: 06.07.14		ADR Date: N/A		
Job No: 00056		Created By: <i>[Signature]</i>	Checked By:	
Product No: D212-722		Approved By:	Approved By:	
Product Name: AVIONICS CONSOLE		(Proj. Manager)	(Management if reqd)	

Documents Affected:
RECEIVE EASA STC: EASA.IM.R.S.01181

#	Engineering Actions	Yes	No	Responsible	To happen by:	Complete
1	Required Documents/Drawings Under Review?	X		KJ	ASAP	06.07.17 <i>[Signature]</i>
2	Update Blue/Pink Folder/Electronic File	X		KJ/PH	06.07.18	06.07.17 <i>[Signature]</i>
3	Update DSI Folder/Electronic File		X			
4	Update D-Part Master Binder		X			
5	Update Grey Project Binder	X		KJ	06.07.18	06.07.17 <i>[Signature]</i>
6	Update DEO/DSI Binder		X			
7	Update Master Document List (MDL)		X			
8	Update Document Record (DR)		X			
9	Update Change Record Form		X			
10	Move Electronic File		X			
11	Notify TC of Change		X			
12	Notify FAA of Change		X			
13	Update QSI 021 (TC/FAA STC)		X			
14	Update QSI 036 (K-Kits)		X			
15	Update Accpac Database		X			
16	Update Access Database	X		KJ	06.07.18	06.07.17 <i>[Signature]</i>
17	Verification ARC	X		KJ/PH	06.07.18	06.07.17 <i>[Signature]</i>
18	Update STC Approval List	X		KJ	06.07.18	06.07.17 <i>[Signature]</i>
19	Update Product Development Summary	X		KJ	06.07.18	06.07.17 <i>[Signature]</i>
20	Create/Update COSS (Estimate/BOM)		X			
21	Create/Update PPP's		X			
22	Update Paperwork Kits in Production	X		KJ	06.07.18	None in Prod <i>[Signature]</i>
23	Update Paperwork Kits in Stock	X		LL/KJ	06.07.18	
24	Red Tag Stock with old CHG #		X			
25	Rework/Scrap Current Production		X			
26	Rework/Scrap Kits in Stock?		X			
27	Update Qpulse/Laminated Dwgs		X			
28	Create/Update Controlled PDF Files	X		KJ	06.07.18	06.07.17
29	Create/Update FAI sheets		X			
30	Create/Update CNC Programs		X			
31	Create/Update Tooling		X			
32	MPP required?		X			
33	Notify Previous Customers		X			
34	Notify Eurocopter France		X			
35						
36						

Description / Action:

ECN Complete: _____ Date: _____

5/25

DART AEROSPACE LTD		Work Order:	<u>23334</u>
Description: Avionics Riser Console		Part Number:	D212-722-011
Dwg: D3360 Rev. A; D3361 Rev. A; D3362 Rev. A; D3363 Rev. B1		Qty:	<u>10</u>
		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	FF	05.05.20	10
2	DC	Photocopy bluefile and create labels per PPP D212-722-011 CHG002			
3	GA	Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360 Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall (M6063T5A0.750W.063) Batch: <u>M17210</u> Identify properly	FF	05.10.24	10
4	GA	Cut (1) D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall (M6063T5C.75x.75W.125) Batch: <u>M17080</u> Identify as D3361-1	FF	05.10.24	10
5	GA	Deburr D3360-1/-3/-5 & D3361-1	FF	05.10.25	10
6	GA	Transfer drill D3360-1/-3/-5 & D3361-1 from D3363-1 as per D3363. Do not rivet together AND C'SINK Pick: Qty Part Number Description Batch 1 D3363-1 Console (Bent) <u>B23353</u>	FF	05.10.27	10
7	GA	Deburr all parts	FF	05.10.28	10
8	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.10.31	10
9	QC3	Inspect Chemical Conversion Coat		05.10.31	10
10	GA	Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rail (PR35-1 or PR3-1/2-1) Batch: <u>M17091</u> Identify as D3362-1	FF	05.10.24	10
11	GA	Rivet D3360-1/-3/-5 & D3361-1 as per Dwg D3363 Pick: Qty Part Number Description Batch 44 MS20426AD4-5 Rivet <u>M4067</u> 9 MS20426AD4-6 Rivet <u>M2930</u> Identify as D3363-041	FF	05.11.04	10
12	QC5	Inspect work to Step 11		05.11.16	10
13	PK	Pick: Packing Kit Qty Part Number Description Batch 1 D3363-041 Console Assembly <u>B23334</u> 8 PFSC35-38A Dzus Fastener <u>M17207</u>		05.11.16	10
14	QC4	Inspect Kit 100% for Completeness on the W/O		05.11.16	10
15	PK	Identify and pack for shipping as per PPP D212-722-011		05.11.16	10
16	AC	Cost / part: <u>199.91</u>		05.11.21	10

PTO

PTO

PTO

10

CL

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-10-24	6	Permanent change As per Dwg.	<i>[Signature]</i>	05-11-21		<i>[Signature]</i>	05-10-24
05-11-16	11	Add D3362-1 rail to ASSY (As per Dwg) permanent change	<i>[Signature]</i>	05-11-21		<i>[Signature]</i>	05-11-16

NCR: 23334		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-11-01 05/11/07 05/11/07	9 10 10	D3362-1 rails were fabricated to completion with the SS wire, then acid etched & Alodined. Alodined by mistake (2) out of Tolerance (4)	<i>[Signature]</i>	Scrap and replace rails with no finish of Alodine. AS per I.P. : Dwg D3362. Destroy Destroy	FF 05.11.07	05-11-14	<i>[Signature]</i>	05-11-01
05-11-14	11	1 rivet had to be drilled out, during drilling the hole was over-sized by .030 (hole was drilled not center), on the D3360-5 Location.	<i>[Signature]</i>	Remove angle care fully without enlarging any more holes. Fill damaged hole with weld on console; angle and grind flush, and touch-up areas with Alodine. See Attached E-mail.	FE 05-11-15	05-11-15	<i>[Signature]</i>	05-11-14
05-11-14 05-11-15	11 11	1 D3360-5 Holes out of Tolerance destroy Replace D3361-1 channel with new one Two Holes To large	<i>[Signature]</i>	Destroy and Replaced 1 D3360-5 Bath # 17695 Destroyed and Replaced	FF 05/11/14 FF 05/11/15	05-11-16	<i>[Signature]</i>	05-11-16

Part No: D212-722-011

PAR #: _____

Fault Category: *Med / Small*NCR: ☒ Yes ☐ NoDQA: *[Signature]*

Date: 05/11/22

NOTE: Date & initial all entries

QA: N/C Closed: *[Signature]*

Date: 05.11.22

DART AEROSPACE LTD		Work Order:	23334
Description: Avionics Riser Console		Part Number:	D212-722-011
Dwg: D3360 Rev. A; D3361 Rev. A; D3362 Rev. A; D3363 Rev. B		Qty:	10
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty
17	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	04.10.21	New issue	KJ/JLM	
B	05.04.11	Now made at Dart	KJ/JLM	

RELEASED
15.04.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

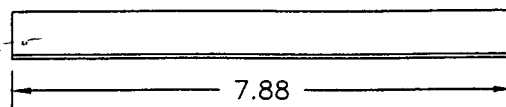
QA: N/C Closed: _____ Date: _____



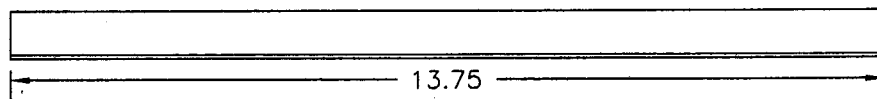
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3360	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE ANGLE	SCALE 1:12
A	04.11.29	NEW ISSUE	

RELEASED

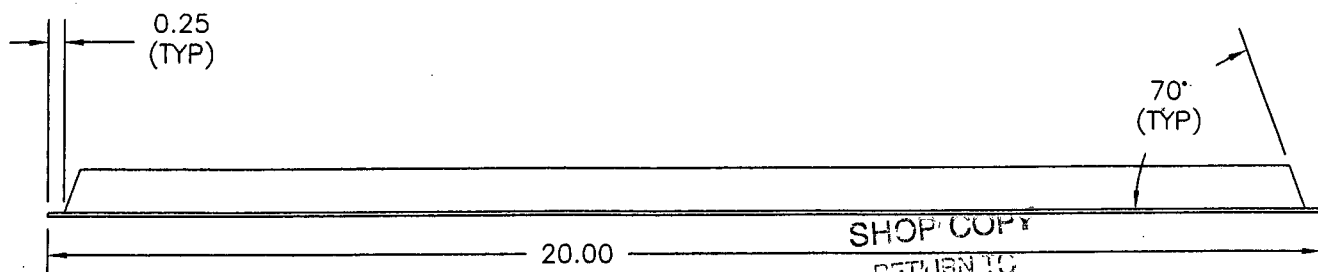
05.03.31 [Signature]



D3360-1
(SCALE 1:3)



D3360-3
(SCALE 1:3)

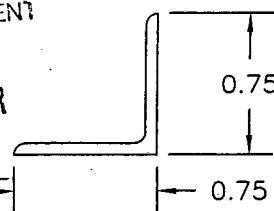


D3360-5
(SCALE 1:3)

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OFFICE

WORK ORDER

NO. 23334



D3360-1/-3/-5 ANGLE

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MATERIAL: 6063-T52 ALUMINUM
STOCK SIZE: 3/4" x 3/4" x 0.063" ANGLE EXTRUSION
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

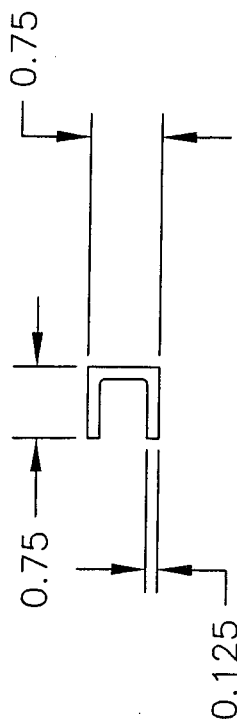
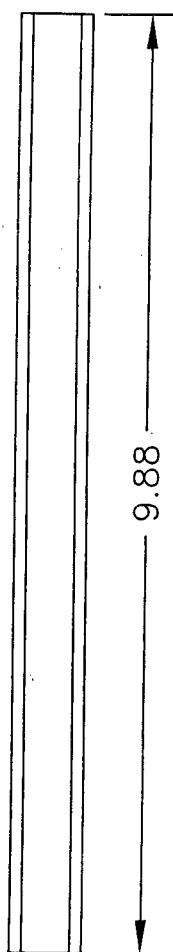
SECTION A-A
(SCALE 1:1)

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CHECKED PH	APPROVED PH	DRAWING NO. D3361	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE CHANNEL	SCALE 1:2
A	04.11.29	NEW ISSUE	



SECTION A-A

RELEASED
05.03.31

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RETUP LTD
ENGINEERS
WORK
NO. 23334

D3361-1 CHANNEL

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MATERIAL: 6063-T52 ALUMINUM
STOCK SIZE: 3/4" x 3/4" x 0.125" CHANNEL EXTRUSION
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

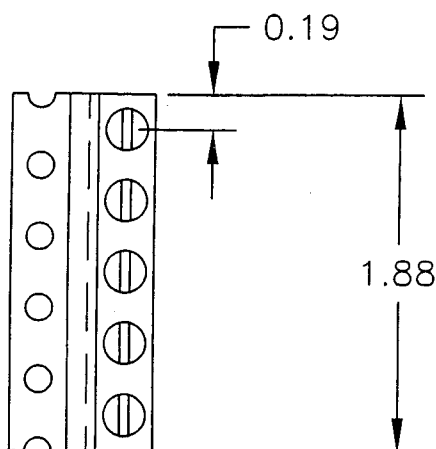
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3362	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE RAIL	SCALE 1:1
A	04.11.29	NEW ISSUE	

RELEASED
05.03.31 [Signature]



D3362-1 RAIL

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MAKE FROM DZUS RAIL P/N "PR 3-1/2-1" OR PR-35-1
- 3) TOLERANCES ARE PER DART QSI 018
- 4) ALL DIMENSIONS ARE IN INCHES

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ENGINEERING
UNLESS IT IS A COPY
SUBMITTED TO THE
QUALITY ASSURANCE
WORK ORDER
NO. 23334

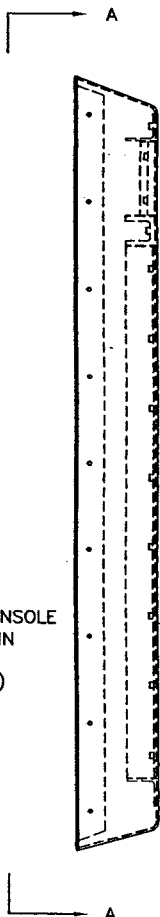
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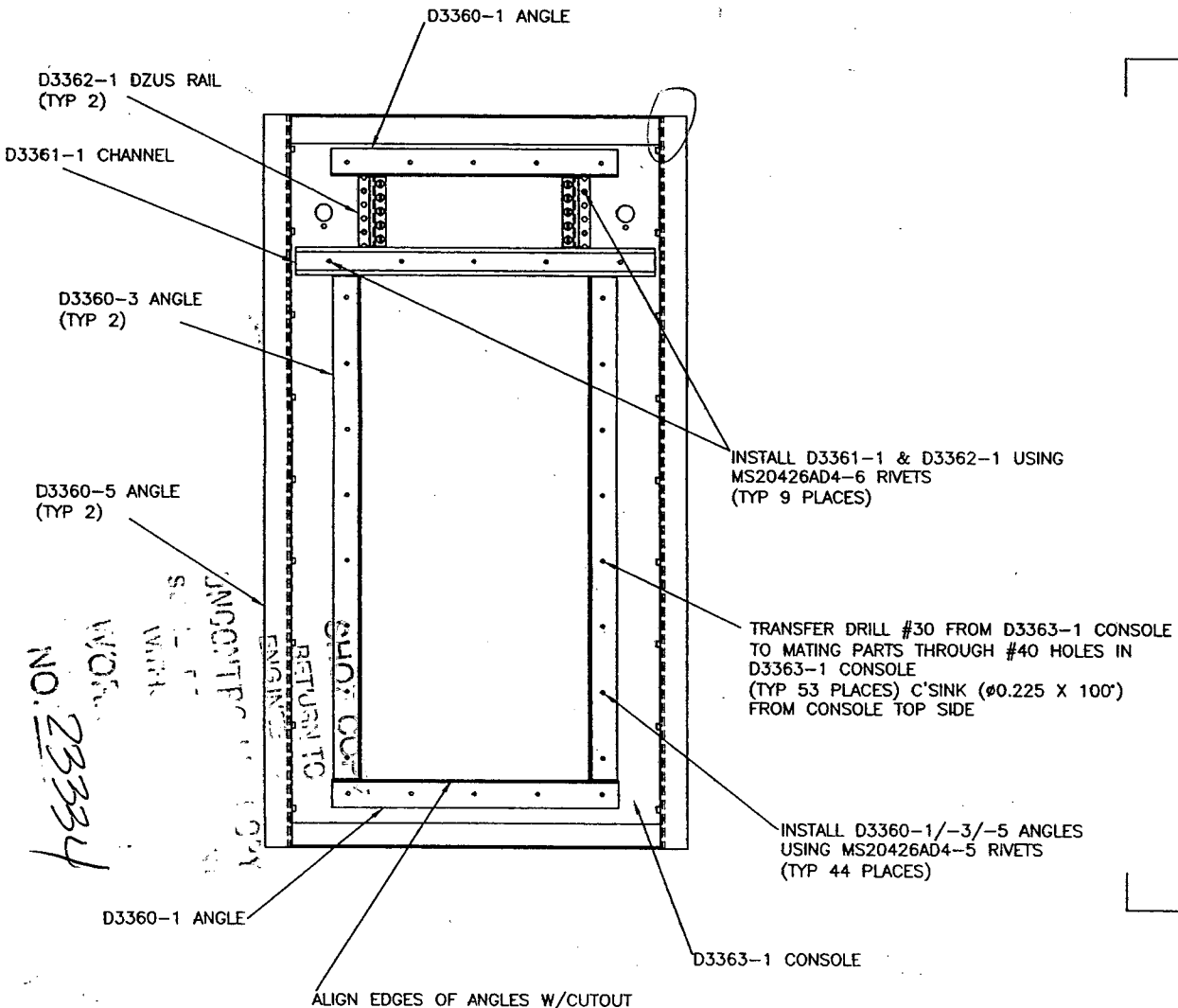
DART

RELEASED
05-03-31

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3363	SHEET 1 OF 3
DATE	05.03.28	TITLE	CONSOLE ASSEMBLY	SCALE	1:5
A	04.11.29	NEW ISSUE			
B	05.03.28	INCREASE WIDTH BY 0.125			
B1	05.04.28	CHANGE WIDTH TO 10.430, WAS 10.43			



C'SINK
THIS SIDE
(REF)



PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

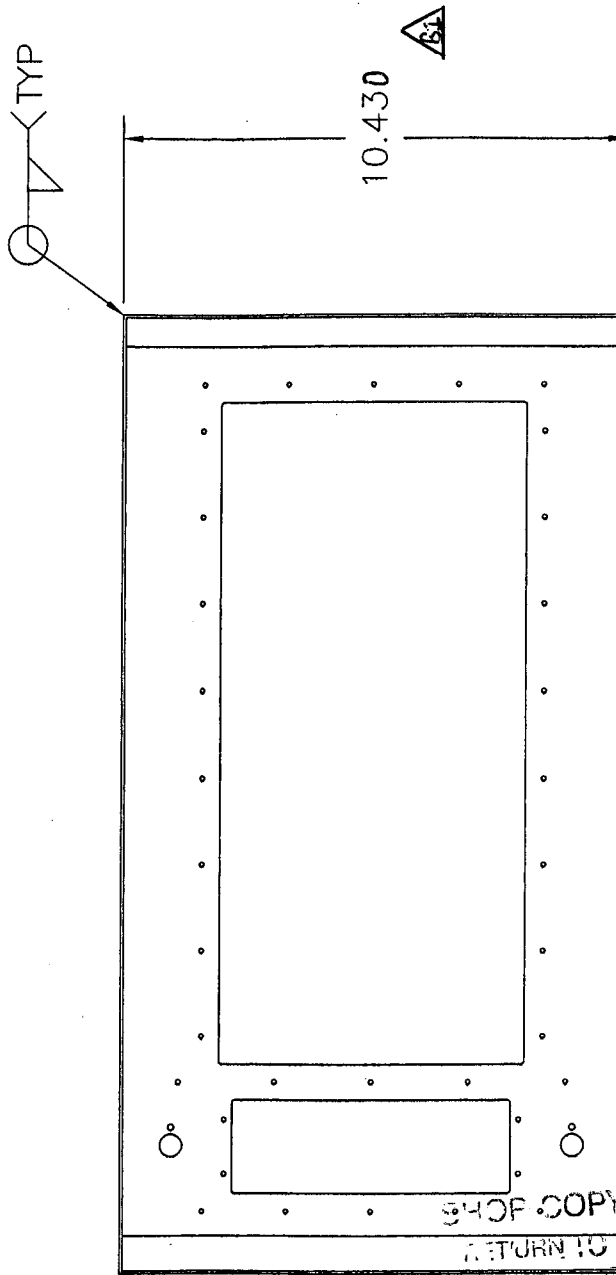
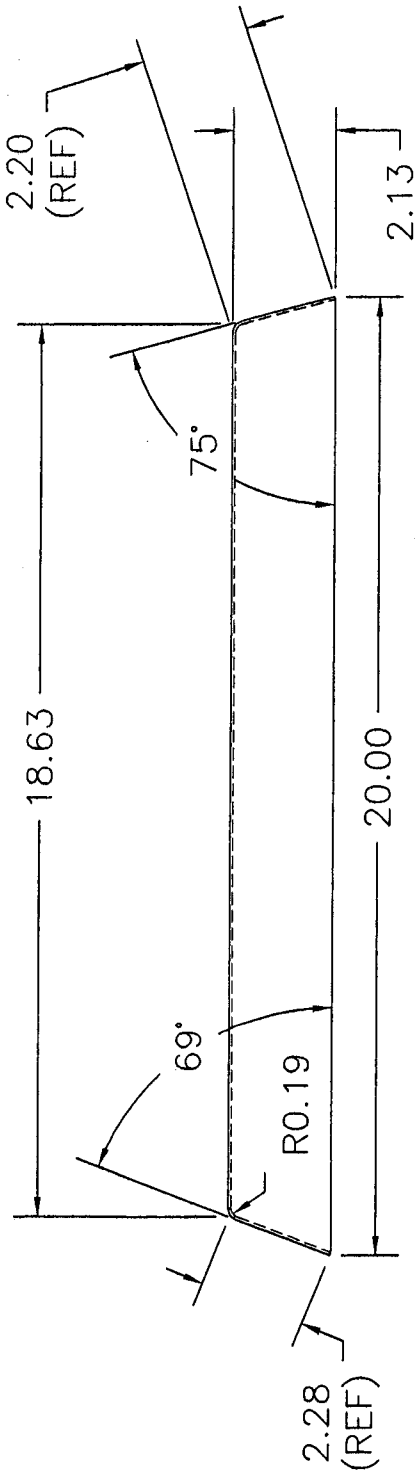
VIEW A-A FROM UNDER CONSOLE ASSEMBLY

D3363-041 CONSOLE ASSEMBLY

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. B SHEET 2 OF 3
DATE 05.03.28	TITLE CONSOLE ASSEMBLY		SCALE 1:4



D3363-1 BEND DETAIL

UNCC: TFC LED COPY
RELEASED SUBJECT TO AMENDMENT
05-03-31 WITHOUT NOTICE
WORK ORDER
NO. 23334

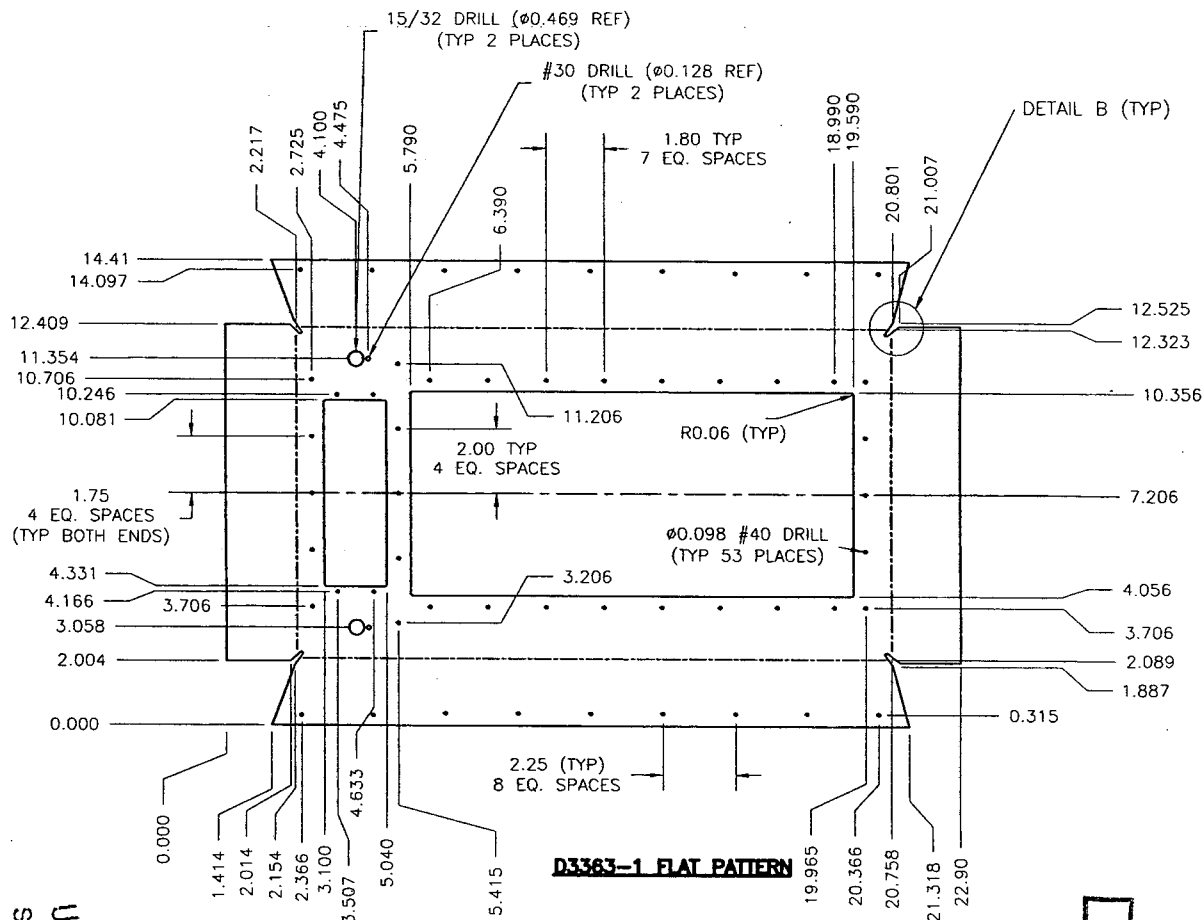
- D3363-1 CONSOLE
- 1) WELD PER DART QSI 004
 - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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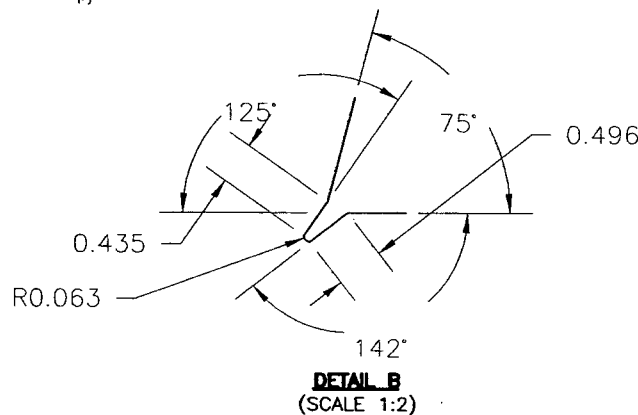
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DESIGN	DRAWN BY	DART AEROSPACE LTD
PH	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3363
DATE	TITLE	REV. B
05.03.28	CONSOLE ASSEMBLY	SHEET 3 OF 3
		SCALE 1:6



D3363-1 FLAT PATTERN



DETAIL B

(SCALE 1:2)

D3363-1 CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (MATERIAL SPEC: QQ-A-250/11) 0.063 THICK (REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

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WITHOUT NOTICE
WORK ORDER
NO. 23334

RELEASED
05.03.31

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 17, 2005
10:51 am

Work Order No : 0023334
Project Name : D212-722-011
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : *D212-722-011
Description : Avionics Console
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 05-17-05
Est Finish Date : 06-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Peter Hum

From: David Shepherd [davids@dartaero.com]
Sent: Tuesday, November 01, 2005 10:54 AM
To: Peter Hum
Cc: Jason Murdoch
Subject: Re: D212-722 console dzus rails

Hi Peter,

Stainless steel should not be acid etched and alodined. I don't know what kind of reaction you are going to have there. Because there are only 10 units involved, my recommendation is that they just scrap them and make 10 more.

David.

----- Original Message -----

From: "Peter Hum" <phum@dartaero.com>
To: "David Shepherd (E-mail)" <davids@dartaero.com>
Sent: Tuesday, November 01, 2005 7:04 AM
Subject: D212-722 console dzus rails

> Hi David,
>
> Production is making a batch on Avionics Riser Consoles. It appears that
> the
> Dzus Rail with the Stainless Steel Rod installed was accidentally Alodine
> and
> Acid Etched. This is contrary to what is on the drawing and IPP (the dwg
> and
> IPP state no finish required). I think the Stainless Steel Rod should not
> be
> alodine and/or acid etched. Do you think this is a problem? or is it
> acceptable to carry on?
>
> FYI - the qty of the batch of rails alodined is 10
>
> Thanks
> Peter Hum
> Mechanical Designer
>
> DART Aerospace Ltd.
> Email...phum@dartaero.com
> Phone...613-632-3336
> Fax.....613-632-4443
>
>

Jason Murdoch

From: David Shepherd [davids@dartaero.com]
Sent: November 9, 2005 9:21 AM
To: Jason Murdoch
Subject: Re:

Hi Jason,

I agree with your suggestion to plug weld this hole and to re-drill and countersink.

David

----- Original Message -----

From: Jason Murdoch
To: davids@dartaero.com
Cc: Peter Hum
Sent: Tuesday, November 08, 2005 11:44 AM

Hey David,

As you can see from the photo's, the #30 hole is over sized, this happened when a rivet was changed. The hole dimension is on the picture. It was mentioned to put a bigger rivet, but I don't think the mat'l is thick enough for a larger c'sink. Is it possible to weld the holes and redrill? I ask this cause the console is almost done, just one more rail to rivet on. The hole inside still has a good edge distance. What do you think? By the way, the mat'l thickness is 0.063 on the console body.

jmurdoch@dartaero.com

A.C. Inspector

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:22 am

Work Order No : 0023334
Project Name : D212-722-011
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : *D212-722-011
Description : Avionics Console
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 05-17-05
Est Finish Date : 06-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	41.00	100.00		
Production Cost :	0.00	616.60	100.00	0.00	616.60
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	616.60	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	616.60			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-616.60)

*MS 0/B
w
11/11*

Date: Saturday, 11/5/2005 11:52:01 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AVIONICS RISER CONSOLE
Job Number : 23334	
Estimate Number : 10259	
P.O. Number :	Part Number : D212722011
This Issue : 11/5/2005 S.O. No. :	Drawing Number : D3363 REV B
Prsht Rev. : NC	Project Number :
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run :	Material :
Written By :	Due Date : 11/30/2005 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est Rev:B 05.04.11 Now made at Dart KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D212-722-011 CHG002

2.0

M6063T5A0750W063

Angle6063T5X.75X.75X.063

3.0

M6063T5C75X75W125

6063 CHANNEL.75X.75X.125

4.0

D33631

CONSOLE

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360Material: 6063-T52 Aluminum
 angle 3/4" x 3/4" x 0.063" wall

2-Cut (1) D3361-1 to length as per Dwg D3361Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall

3-Deburr D3360-1/-3/-5 & D3361-1

4-Transfer drill D3360-1/-3/-5 & D3361-1 from D3363-1 as per D3363. Do not rivet together

5-Deburr all parts

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Date: Saturday, 11/5/2005 11:52:01 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 23334

Part Number: D212722011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PR351

DZUS FASTENER RAIL

9.0

MS20426AD45

Rivet

10.0

MS20426AD46

Rivet

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3362-1 to length as per Dwg D3362Material: Dzus Fastener Rail

2-Rivet D3360-1/-3/-5 & D3361-1 as per Dwg D3363
Identify as D3363-041

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

14.0

PFSC3538A

Dzus 1/4 turn fastener

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D212-722-011

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21